

thereby engaging the root point P defined by the circular bottom pattern tool 33 and the flange-shaped portion 13, --.

Page 13, line 24, between the "," and "so" insert --  
thereby engaging the root point P defined by the circular bottom pattern tool 33 and the flange-shaped portion 13, --.

IN THE CLAIMS:

Please amend claim 5 as follows:

5. (Twice Amended) A method of [thickening an] forming  
a thickened annular peripheral wall of a sheet metal member,  
comprising the steps of: holding a base plate of [a disc] the sheet  
metal member [having said base plate] and forming a flange-shaped  
portion integrally [formed at] with an outer periphery of [said]  
the base plate[, ] ; inserting the flange-shaped portion between a  
circular bottom pattern tool and a circular top pattern tool;  
applying recessed annular forming faces of circular rollers of  
plural kinds against the flange-shaped portion and sequentially  
pressing [said] the flange-shaped portion projecting outwardly from  
[said] the circular bottom pattern tool and said circular top  
pattern tool, in a radially inward direction and against a root  
point defined by the circular bottom pattern tool and the flange-  
shaped portion [by recessed annular forming faces of circular  
rollers of plural kinds each having a recessed annular forming  
face], thereby sequentially thickening a rear side of said flange-  
shaped portion; and forming [said] the thickened flange-shaped  
portion into a cylindrical shape which is concentric with [said]  
the base plate, thereby forming [a] the thickened annular